

Work Order ID 141769

Thursday, February 11, 2016 10:24:38 AM

141769

Page 1

Item ID: D3188-2M Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacepod Body RH
Start Date: 2/11/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/18/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MUS Date: FEB 11 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3188	G

100

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 31394

Description: D3188-2P BODY

SHIP: QTY (8) D2213 Spacers

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

0.00

0.00

DAS
13
9-89

FEB 17 2016

1

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

0.00

CANCEL

JAN 10 2017

DAS
13
9-89

1x sp/16-6-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

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Page 2

Item ID: D3188-2M Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacepod Body RH
Start Date: 2/11/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/18/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo Check for void spot and pins.	0.00 0.00				_____	_____	_____	_____
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				_____	_____	_____	_____
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				_____	_____	_____	_____

CL 17/01/10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Page 1

Thursday, February 11, 2016 10:24:41 AM

Work Order ID: 141769

141769

Parent Item: D3188-2M

D3188-2M

Parent Item Name: Spacepod Body RH

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC
IPP rev B rev D dwg 07.03.07 ec
IPP rev C rev E dwg 07.04.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2213		Manufactured	No			100	Each	42.0000	8	8			
D2213									**				
Insert													
					<u>Location</u>								
					ST003			42					
					30809			42					
D3188-2P		Purchased	No			110	Each	0.0000	1	1			
D3188-2P									**				
Spacepod Body													

CL 16/02/22

✓

1x SP16-6-29

GENERAL NOTES:**1) MATERIALS:**

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLESFOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN**1. MOLD SCHEDULE:**

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

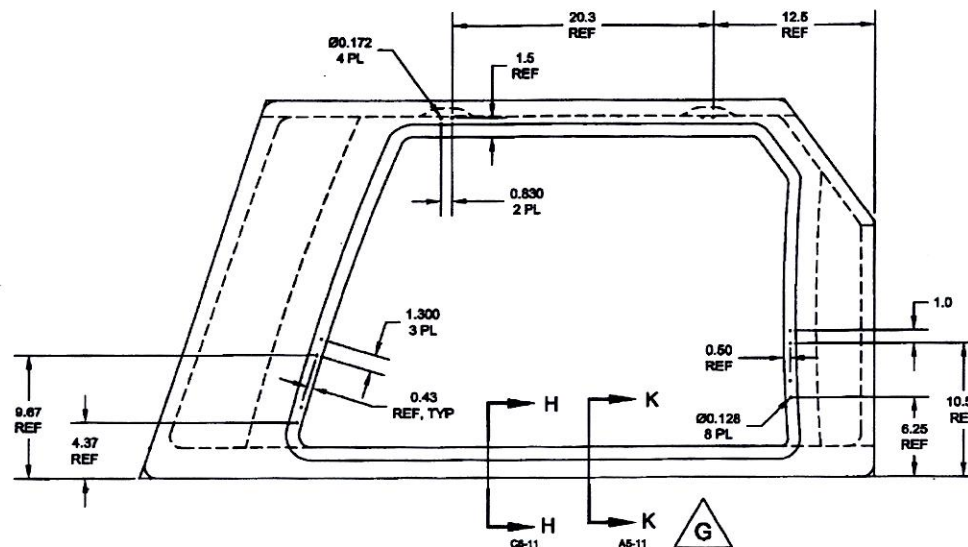
8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

10) POT INSERTS PER QSI 006 SECTION 4.16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 141769 MLC
16-02-11RELEASED
2014-07-28

G	ADD SECTION K-K/L-L: INSERT INSTALLATION TO SHEET 11 (ZN A5-11)	DB	14.06.20
F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS: ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 1 OF 11
APPROVED		TITLE	SCALE
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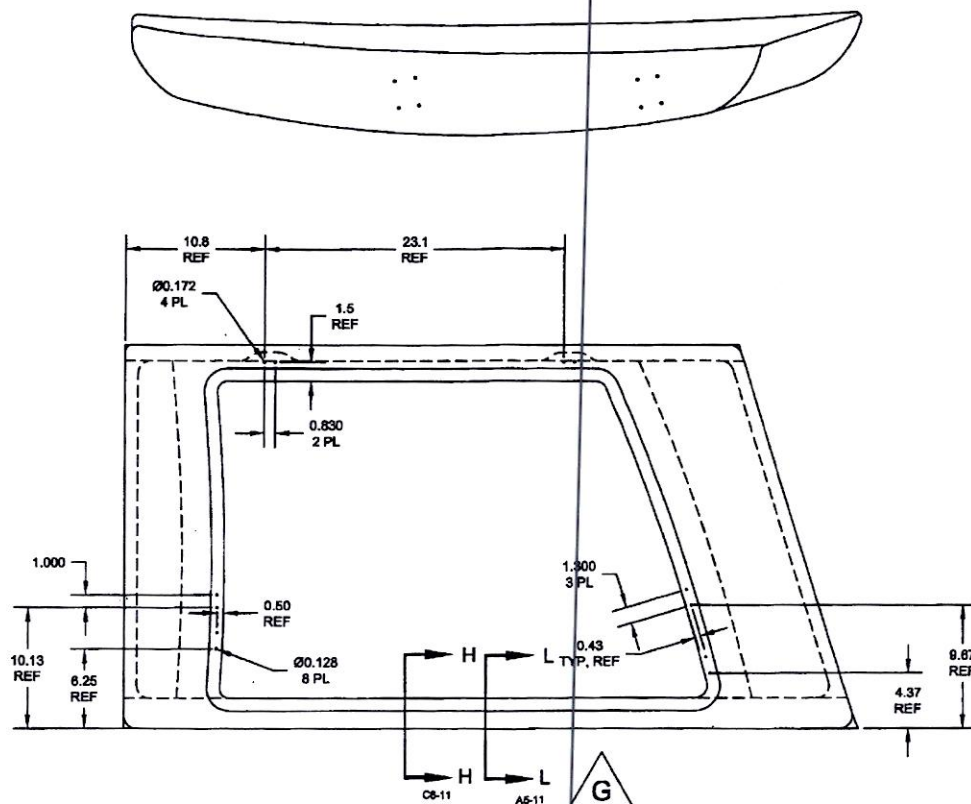
D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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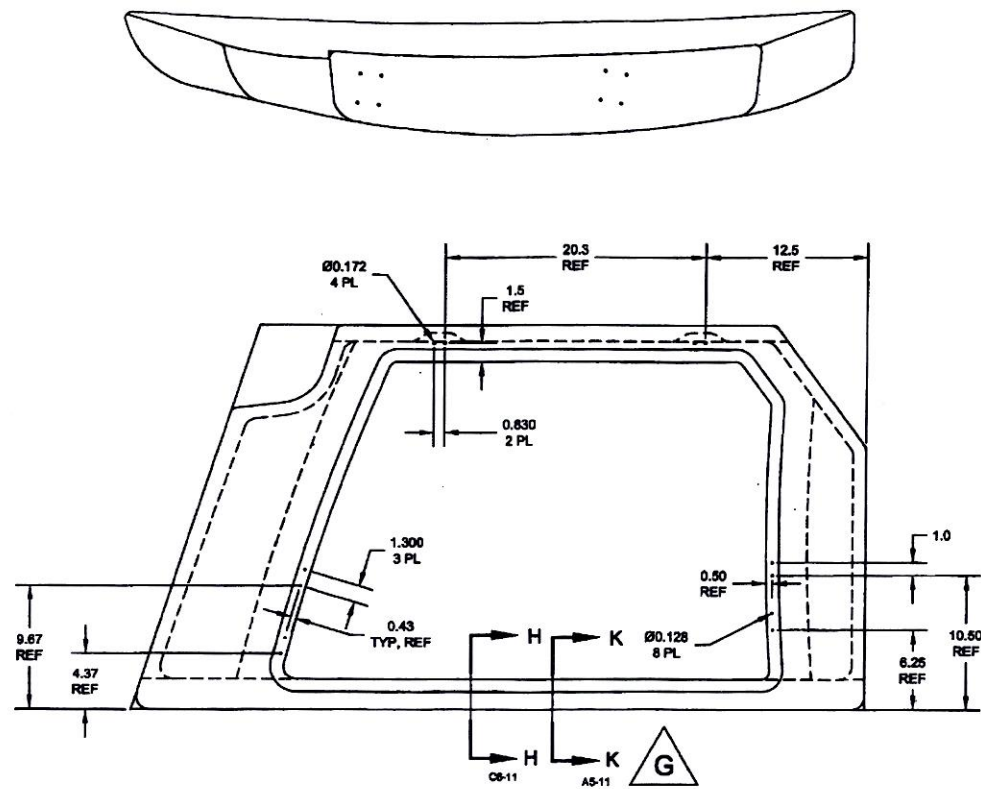
D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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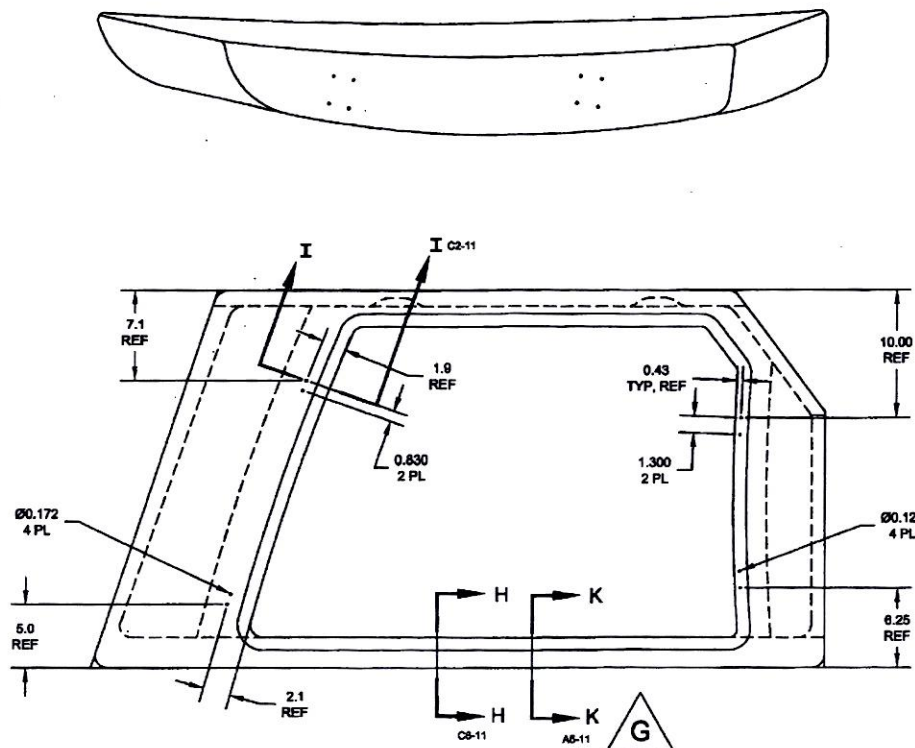


D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

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2014-07-28

- NOTES:**
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

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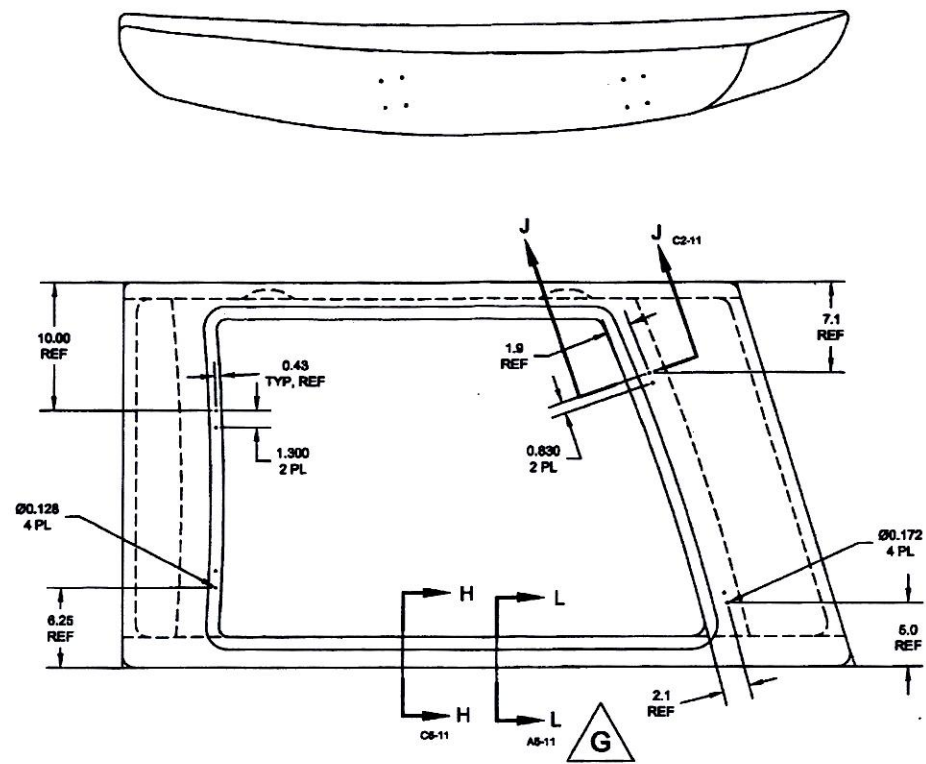
D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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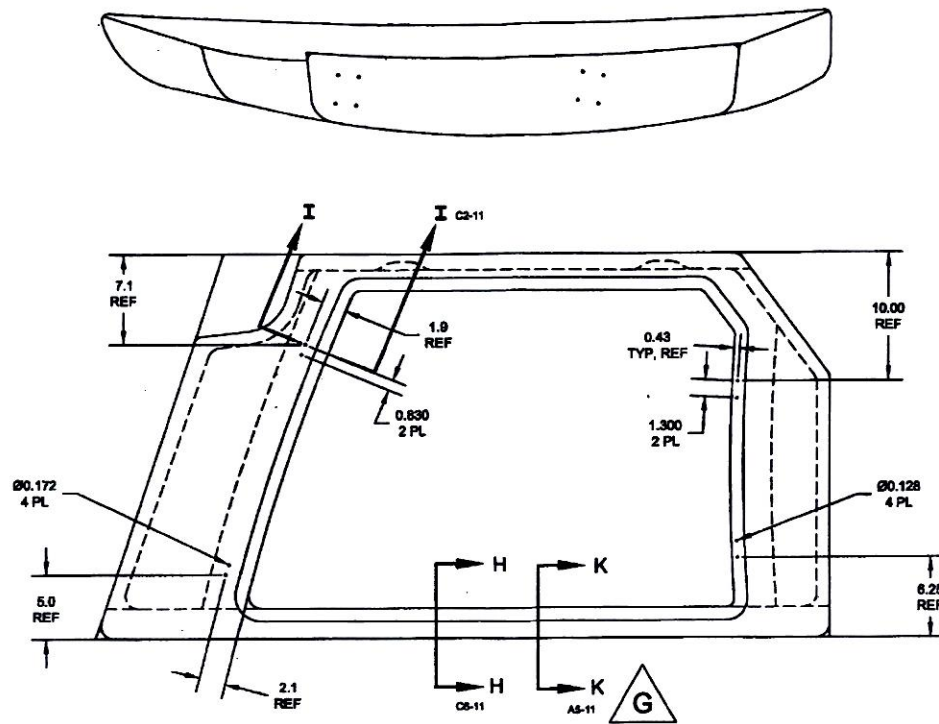
D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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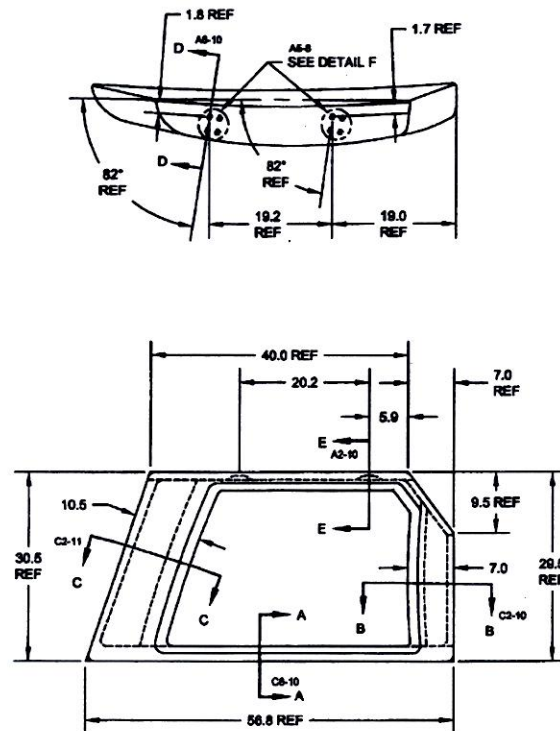
D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

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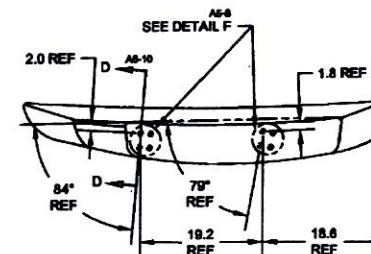
NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

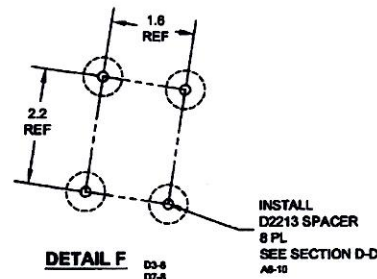
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D3188-1M SPACEPOD BODY



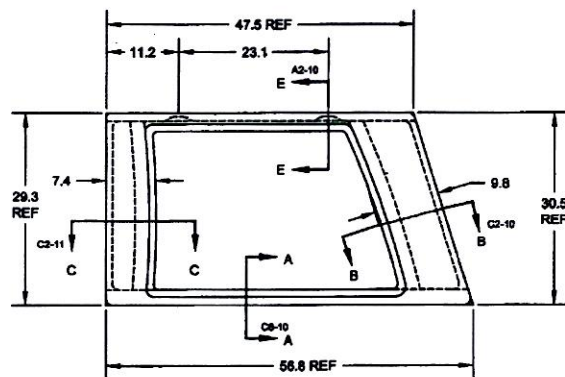
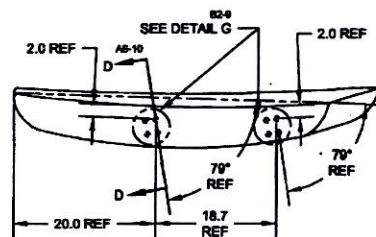
D3188-3M SPACEPOD BODY



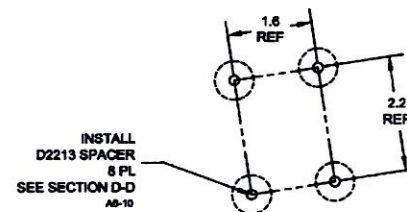
- D3188-1M/-3M NOTES:**
 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
 2) SEE SHEET #10 FOR SECTION VIEWS.

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D3186-2M SPACEPOD BODY



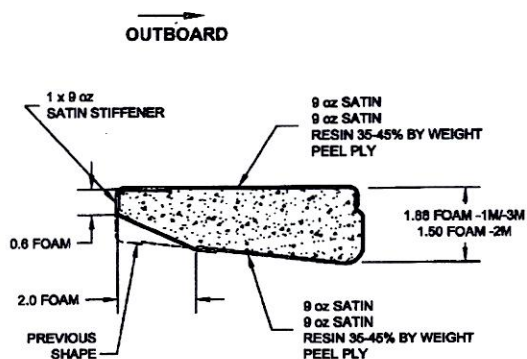
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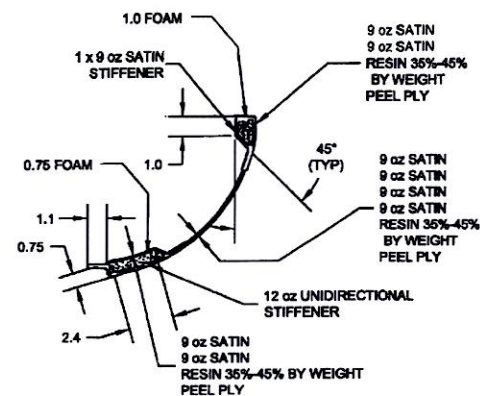
- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

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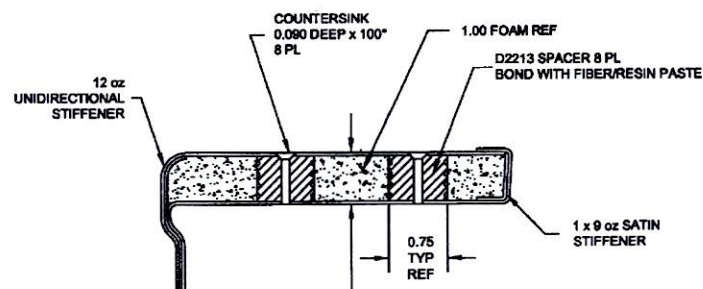
SECTION A-A
TYPICAL FLOOR SECTION

B7-4
B3-4
B6-4



SECTION B-B
SECTION C-C OPPOSITE

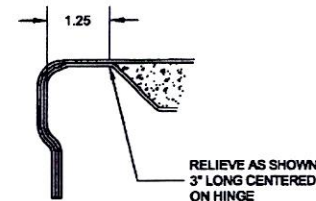
B6-4
B8-4
B4-4
B2-4
B7-4
B5-4



SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS

D3-4
D7-4
D8-4

9 oz SATIN
9 oz SATIN
18 oz CLOTH
1.00 FOAM
9 oz SATIN
9 oz SATIN
RESIN 35-45% BY WEIGHT
PEEL PLY

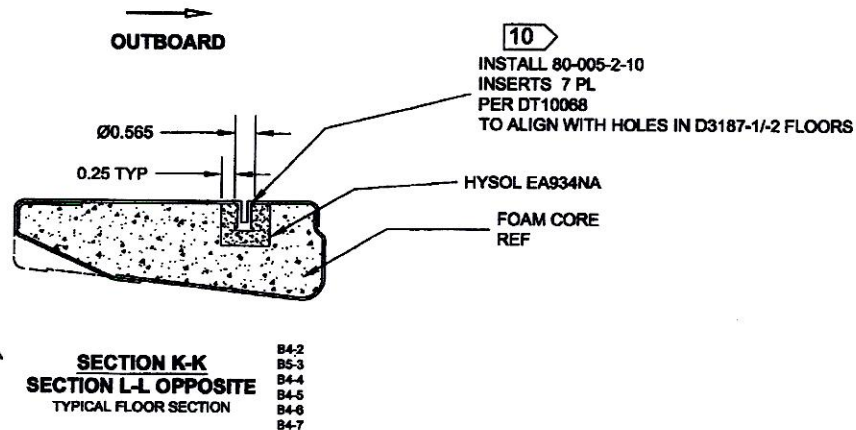
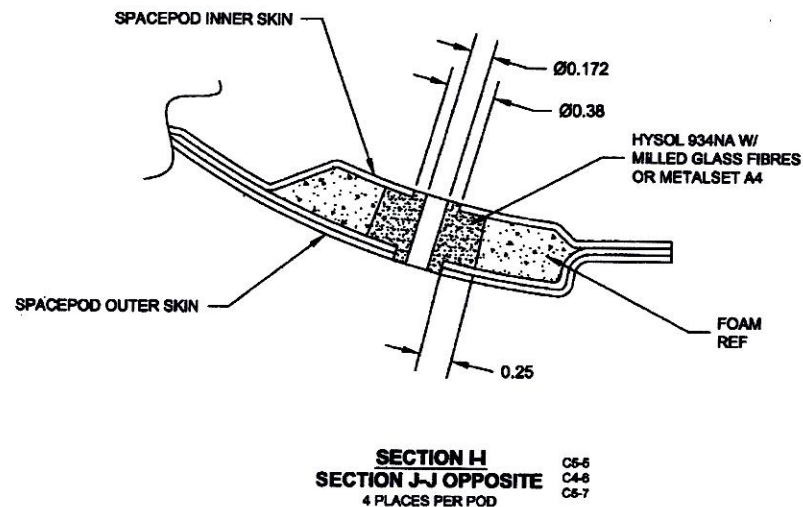
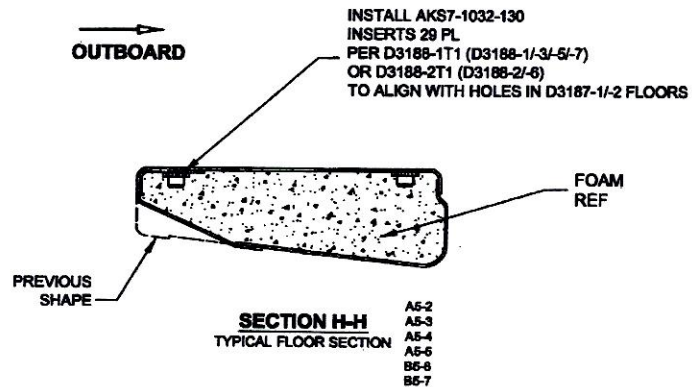


SECTION E-E
2 PLACES PER POD

C3-4
C7-4
B6-4

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2014-07-28

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
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RELEASE
2014-07-28

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DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

Purchase Order ID PO31394

Purchase Order Date 2/17/2016
PO Print Date 2/17/2016

Page Number 1 of 3

Order From :

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

VC-FDC01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
FEB 18 2016

Contact Name
Vendor Phone

450-357-1344 ext303

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3188-2P AS PER DWG D3188 REV.G B141769	Spacepod Body	3/31/2016 Yes 3/31/2016		1.00 Each	\$2,460.00	\$2,460.00
Line Total:							\$2,460.00
2	D3186-2P AS PER DWG D3186 REV.E B135276	Spacepod Door	3/31/2016 Yes 3/31/2016		1.00 Each	\$810.00	\$810.00
Line Total:							\$810.00
3	D3188-2P AS PER DWG D3188 REV.G B137538	Spacepod Body	7/27/2016 Yes 7/27/2016		1.00 Each	\$2,460.00	\$2,460.00

Note:

2/17/2016

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tél.: 450 357-1344

Bon de livraison 29/04/2016

Commande : 2443
Référence : PO #31394/1

Client : Dart

Expédier à

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Même

Tél.: 1 613 632-9577

No item	Description	Qté	Qté livrée	Qté B/O
D3188-2P ✓	Spacepod Body PO item: 31394/1 Lot: 2016-03-31 <u>B141769</u> NOTE : FAI article, PO Item 1. CANADIAN CURRENCY	1 ✓	_____	_____

Sp 16-6-29

Transport : _____
Nb colis : _____

Réf. : _____



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 31394

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number Part</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
1	1	D3188-2P Spacepod Body	D3188 Rev.G	B141769	DAE014-001	2016-03-31

NOTE : FAI article, PO Item 1.

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: 
Jules Fournier, BDI, Quality Manager

Date: 2016-04-29